

304 67500 X .09147



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**D2282-7****Job Sheet 214344****Part No:** D2282-7**Job Qty:** 100 pcs**Part Name:** Tube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/22/20**Job Tracking No:****Due Date:** 12/11/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation    | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier             | Sign-off    |
|-------|--------------|---------|------------|----------|-----------|---------|---------------------------------|-------------|
|       |              |         |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier Lead Time |             |
| 100   | Hardinge - 1 | 100 pcs | 12/11/20   | 12/11/20 | 0.02      | 2.61    | Hardinge - 1                    | DE 20/11/20 |
| 120   | QC 8         | 100 pcs | 12/11/20   | 12/11/20 | 0.00      | 0.00    | QC 8 - 12                       | mk 20/12/20 |
|       |              |         |            |          |           |         | QC 8 - 14                       |             |
|       |              |         |            |          |           |         | QC 8 - 17                       |             |
|       |              |         |            |          |           |         | QC 8 - 20                       |             |
|       |              |         |            |          |           |         | QC 8 - 25                       |             |
|       |              |         |            |          |           |         | QC 8 - 3                        |             |
|       |              |         |            |          |           |         | QC 8 - 32                       |             |
|       |              |         |            |          |           |         | QC 8 - 33                       |             |
|       |              |         |            |          |           |         | QC 8 - 35                       |             |
|       |              |         |            |          |           |         | QC 8 - 39                       |             |
|       |              |         |            |          |           |         | QC 8 - 4                        |             |
|       |              |         |            |          |           |         | QC 8 - 44                       |             |
|       |              |         |            |          |           |         | QC 8 - 45                       |             |
|       |              |         |            |          |           |         | QC 8 - 49                       |             |
|       |              |         |            |          |           |         | QC 8 - 58                       |             |
|       |              |         |            |          |           |         | QC 8 - 8                        |             |
|       |              |         |            |          |           |         | QC 8 - 9                        |             |
|       |              |         |            |          |           |         | QC 8 - 68                       |             |
|       |              |         |            |          |           |         | QC 8 - 67                       |             |
|       |              |         |            |          |           |         | QC 8 - 1 (A)                    |             |
|       |              |         |            |          |           |         | QC 8 - 47                       |             |
|       |              |         |            |          |           |         | QC 8 - 40                       |             |
|       |              |         |            |          |           |         | QC 8 - 52                       |             |
|       |              |         |            |          |           |         | QC 8 - 23                       |             |
|       |              |         |            |          |           |         | QC 8 - 57                       |             |
|       |              |         |            |          |           |         | QC 8 - 76                       |             |
|       |              |         |            |          |           |         | QC 8 - 61                       |             |
|       |              |         |            |          |           |         | QC 8 - 66                       |             |
|       |              |         |            |          |           |         | QC 8 - 73                       |             |
|       |              |         |            |          |           |         | QC 8 - 82                       |             |

**Container No:** S318474**Part:** D2282-7**Job No:** 214344**Serial No/Batch:** S318474**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 12/05/20

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|                                         |          |           |                        |                |
|-----------------------------------------|----------|-----------|------------------------|----------------|
| 130 Packaging 3-1 - Stock - B4B 100 pcs | 12/11/20 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                |
|                                         |          |           | Packaging 3 - 2 - B4B  |                |
|                                         |          |           | Packaging 3 - 3 - B4B  |                |
|                                         |          |           | Packaging 3 - 4 - B4B  |                |
|                                         |          |           | Packaging 3 - 5 - B4B  |                |
|                                         |          |           | Packaging 3 - 6 - B4B  |                |
|                                         |          |           | Packaging 3 - 7 - B4B  |                |
|                                         |          |           | Packaging 3 - 8 - B4B  |                |
|                                         |          |           | Packaging 3 - 9 - B4B  |                |
|                                         |          |           | Packaging 3 - 10 - B4B |                |
|                                         |          |           | Packaging 3 - 11 - B4B | DAS            |
|                                         |          |           | Packaging 3 - 12 - B4B | 50 DEC 07 2020 |
|                                         |          |           | Packaging 3 - 13 - B4B | 9-89           |
|                                         |          |           | Packaging 3 - 14 - B4B |                |
|                                         |          |           | Packaging 3 - 15 - B4B |                |
|                                         |          |           | Packaging 3 - 16 - B4B |                |
|                                         |          |           | Packaging 3 - 17 - B4B |                |
|                                         |          |           | Packaging 3 - 18 - B4B |                |
|                                         |          |           | Packaging 3 - 19 - B4B |                |
|                                         |          |           | Packaging 3 - 20 - B4B |                |
|                                         |          |           | Packaging 3 - 21 - B4B |                |
|                                         |          |           | Packaging 3 - 22 - B4B |                |
|                                         |          |           | Packaging 3 - 23 - B4B |                |
|                                         |          |           | Packaging 3 - 24 - B4B |                |
|                                         |          |           | Packaging 3 - 25 - B4B |                |
|                                         |          |           | Packaging 3 - 26 - B4B |                |
|                                         |          |           | Packaging 3 - 27 - B4B |                |
|                                         |          |           | Packaging 3 - 28 - B4B |                |
|                                         |          |           | Packaging 3 - 29 - B4B |                |
|                                         |          |           | Packaging 3 - 30 - B4B |                |
|                                         |          |           | Packaging 3 - 31 - B4B |                |
|                                         |          |           | Packaging 3 - 32 - B4B |                |
|                                         |          |           | Packaging 3 - 33 - B4B |                |
|                                         |          |           | Packaging 3 - 34 - B4B |                |
|                                         |          |           | Packaging 3 - 35 - B4B |                |
|                                         |          |           | Packaging 3 - 36 - B4B |                |
|                                         |          |           | Packaging 3 - 37 - B4B |                |
| 140 QC 21 - SA 100 pcs                  | 12/11/20 | 0.00 0.00 | QC 21 - SA - 21        | DAS            |
|                                         |          |           | QC 21 - SA - 70        | 21 DEC 07 2020 |
|                                         |          |           | QC 21 - SA - 9         | 9-89           |
|                                         |          |           | QC 21 - SA - 77        |                |
|                                         |          |           | QC 21 - SA - 28        |                |

Part Op 100 - (Hardinge) 1-Turn as per Dwg D2282 and Folio FA190  
 Descriptions: 120 - (QC8- Inspect parts - second check)  
 130 - Identify as per dwg & Stock Location: WA001-1. \*\*\*STOCK IN LARGE FAB\*\*\*  
 140 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item     | Component Name                             | Quantity             | Operation        | Container |
|-----------------|--------------------------------------------|----------------------|------------------|-----------|
| M304P0.675W.091 | 304/316 Pipe .675 OD x .091 Wall Thickness | 6.6600 ft (.0666 ea) | 100-Hardinge - 1 | 5246238   |

## Job Allocations

| Operation        | Component Part  | Required | Inventory | Allocated |
|------------------|-----------------|----------|-----------|-----------|
| 100-Hardinge - 1 | M304P0.675W.091 | 7        | 37        | 0         |

| Part Specifications |             |                         |                |      |                  |
|---------------------|-------------|-------------------------|----------------|------|------------------|
| Spec No             | Description | Target/Tolerance        | Limits         | Type | Special Comments |
| 1                   | Handle Tube | 0.795Inches $\pm$ 0.010 | 0.805<br>0.785 |      |                  |
| 2                   | Handle Tube | 0.493Inches $\pm$ 0.010 | 0.503<br>0.483 |      |                  |
| 3                   | Handle Tube | 0.675Inches $\pm$ 0.010 | 0.685<br>0.665 |      |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |